

Work Order ID 110836**D 3 5 3 6 - 3 3*****110836***

January-07-14 3:09:12 PM

Page 1

Item ID: D3536-33

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Gasket Aft

Stop

NS2

Start Date: 1/07/14 Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/07/14 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: MLJDate: 14-01-08

Tooling:

Date:

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N):

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3536	Rev A								

100

100

FLOW WATER JET

Waterjet

FLOW CNC Waterjet

Neo .063

Memo 0.00

1-Cut as per Dwg D3536 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary13 0 Jm14-01-14

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo 0.00

13 0 Jm14-01-14

120

QC8- Inspect parts - second check

0.00

120

QC

Quality Control

DAS

27

9.89

0.00 14/1/1513 _____

DQA:

Date:



QA Closed:

Date:

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

Work Order:				DISPOSITION		AGAINST DEPARTMENT/PROCESS																
Part No.				Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Machining <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/>	Quality <input type="checkbox"/>	Other <input type="checkbox"/>
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification		QC Inspector										
Design																						
Doc/Data																						
Equip/Tooling																						
Handling/Pre																						
Material																						
Operator																						
Offset/Setup																						
Process																						
Supplier																						
Training																						
Transport																						
Unapproved																						
FAULT CATEGORY																						
Landing Gear	General																					
	<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions						<input type="checkbox"/> Pressure/Forced												
	<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance						<input type="checkbox"/> Set-up												
	<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect						<input type="checkbox"/> Temperature/Cure												
	<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing						<input type="checkbox"/> Weld												
	<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved						<input type="checkbox"/> Wrong Stock Pulled												
	<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong						<input type="checkbox"/> Other												
	<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge																		
	<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread																			
	<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set																			
	<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration																			
	<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence																			

Work Order ID 110836***110836***

January-07-14 3:09:12 PM

Page 2

Item ID: D3536-33

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Gasket Aft

Stop

NS2

Start Date: 1/07/14 Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/07/14 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
Description

130

Identify as per dwg & Stock Location:F10-0Q1***130***

Packaging

Packaging

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.00

X 13 f 14/01/1514-01-1514-01-15

DQA:

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: _____

Work Order update only

Work Order: _____
 Part No. _____
 NCR No. _____

DISPOSITION

Rework
 Scrap
 Use-as-is
 Suspected Unapproved

AGAINST DEPARTMENT/PROCESS

Skid-tube
 Machining
 Thermoforming
 Large Fab

Crosstube
 Small Fab
 Finishing
 Composite

Water Jet
 Prod. Eng. Coor.
 Rec/Store/Packaging
 Supplier

Engineering
 Quality
 Other

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General									
		Bending <input type="checkbox"/>	Golf/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>						
		Centre Not Concentric <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>						
		Cracks <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>						
		Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>						
		Cuffs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>						
		Crushing <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>							
		Heat Treat <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>						
		Inspection Strip in Tube <input type="checkbox"/>	Misread <input type="checkbox"/>								
		Marks/Chatter <input type="checkbox"/>	Off-set <input type="checkbox"/>								
		Turning Sequence <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>								
		Wave/Twist in Tube <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>								

Picklist Print

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Page 1

Work Order ID: 110836

Parent Item: D3536-33

Parent Item Name: Gasket Aft

Start Date: 1/07/14

Required Date: 1/07/14

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	121.4000	0.6456	43039998	9.	JM14-01-14	
NEOPRENE SHEET 0.063													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				MAT052			121.4						
					M126546		121.4						126546

DQA:

Date:



WORK ORDER NON-COMPLIANCE / UPDATE

QA Closed:

Date:

Work Order update only

DART AEROSPACE LTD	Work Order:	110836
Description: Gasket	Part Number:	D3536-33
Inspection Dwg: D3536	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

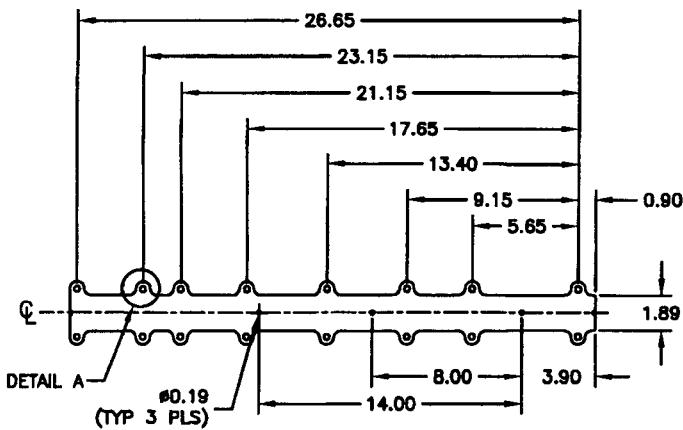
X First Article Prototype

DAS

Measured by:	<i>Jm</i>	Audited by:	<i>27 e-89</i>	Prototype Approval:	N/A
Date:	<i>14-01-14</i>	Date:	<i>14-1-15</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	M



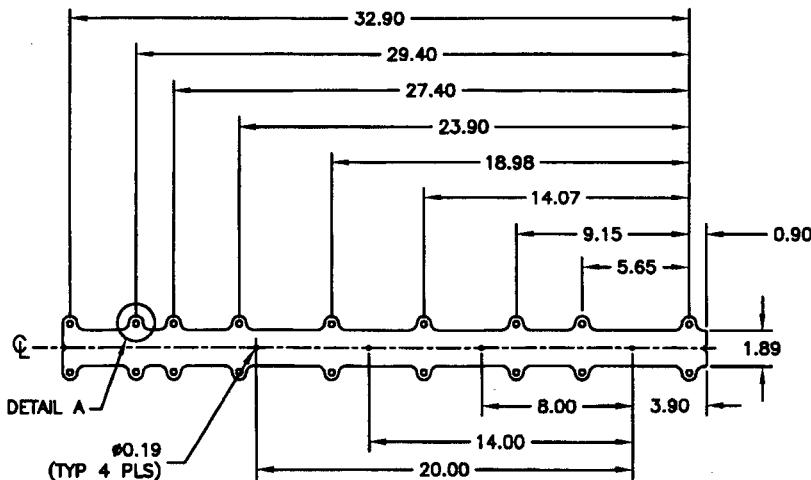


D3536-11 GASKET

110836 MUS
14-01-08

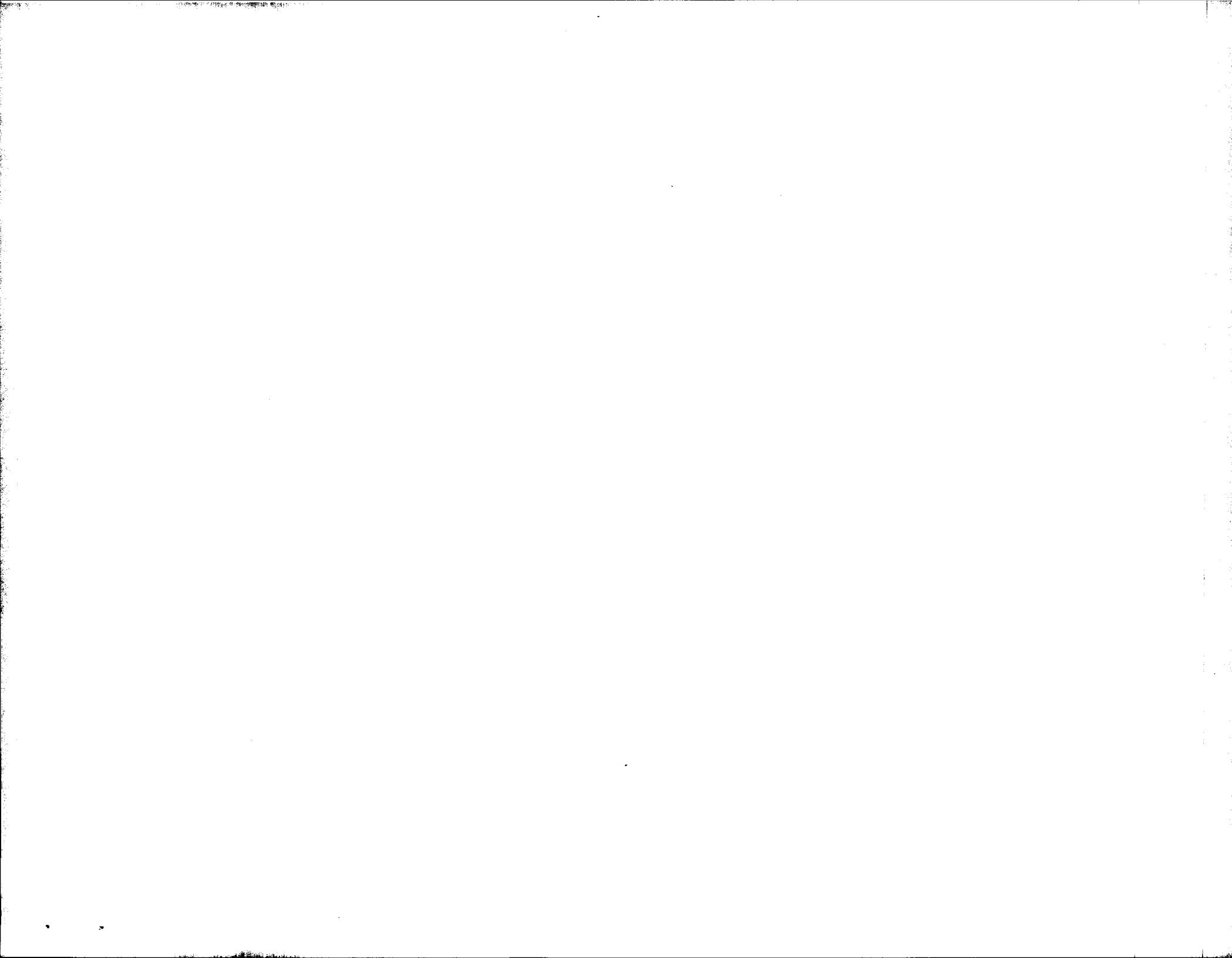
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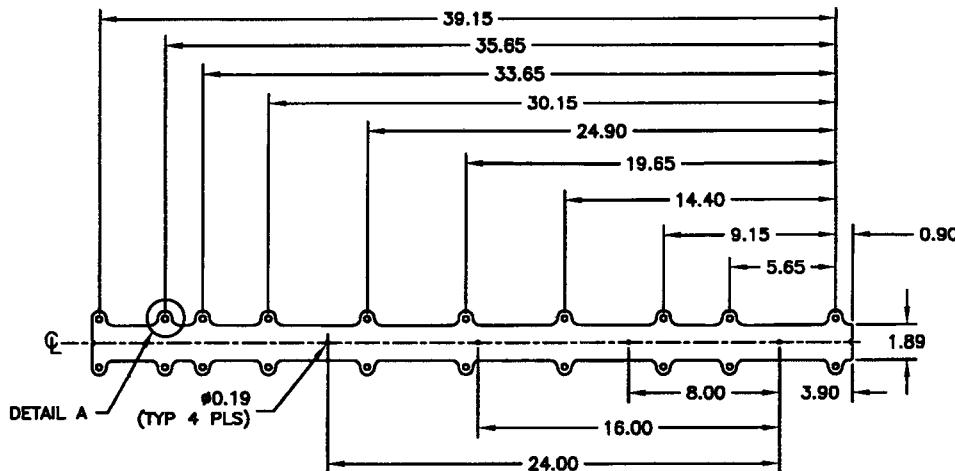
DART



D3536-13 GASKET

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C8	C8	
CHECKED	APPROVED	DRAWING NO.
<i>Pf</i>	<i>H</i>	D3536
DATE		TITLE
06.10.25		GASKET
A	06.10.25	NEW ISSUE
REV. A		SHEET 1 OF 6
SCALE		1:10





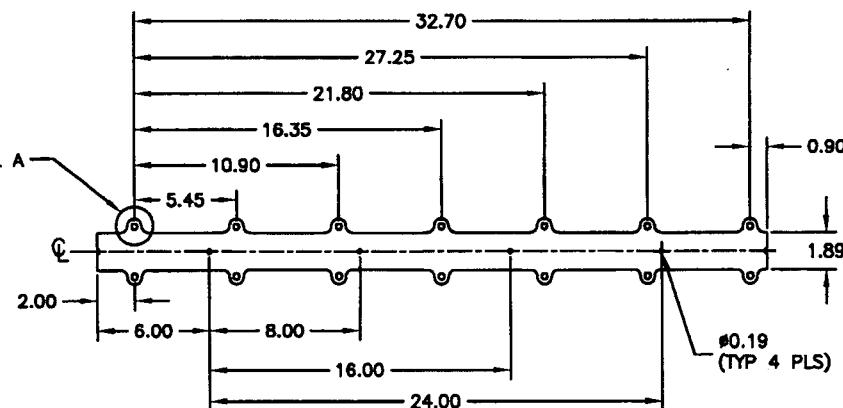
D3536-15 GASKET

07.02.12
FBI LABS



DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	SHEET 2 OF 6

REV. A
SCALE
1:10



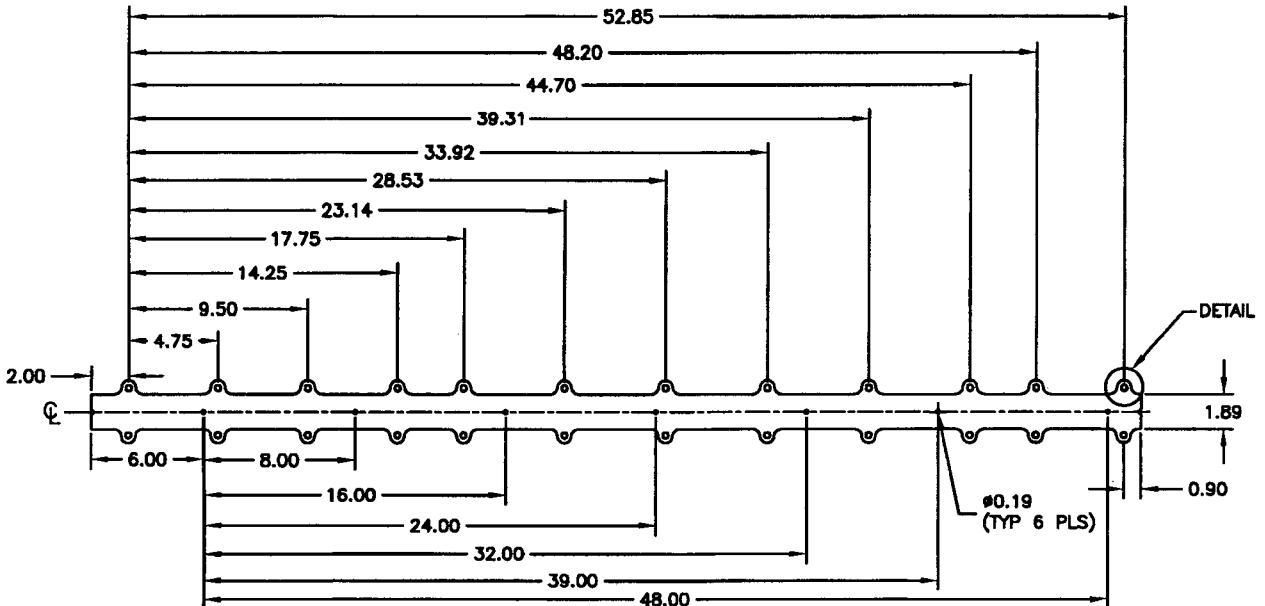
D3536-21 GASKET

NOTES

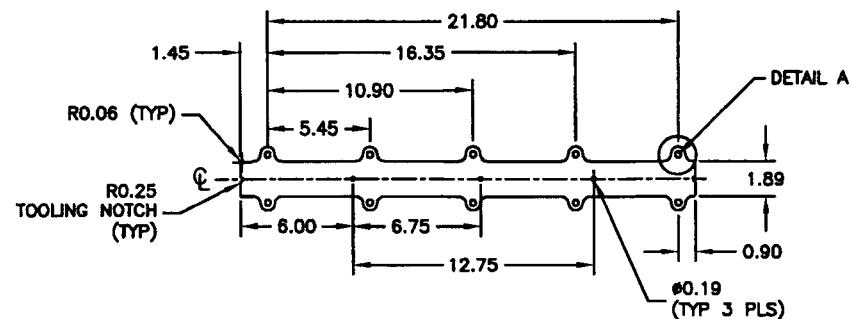
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- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

DART

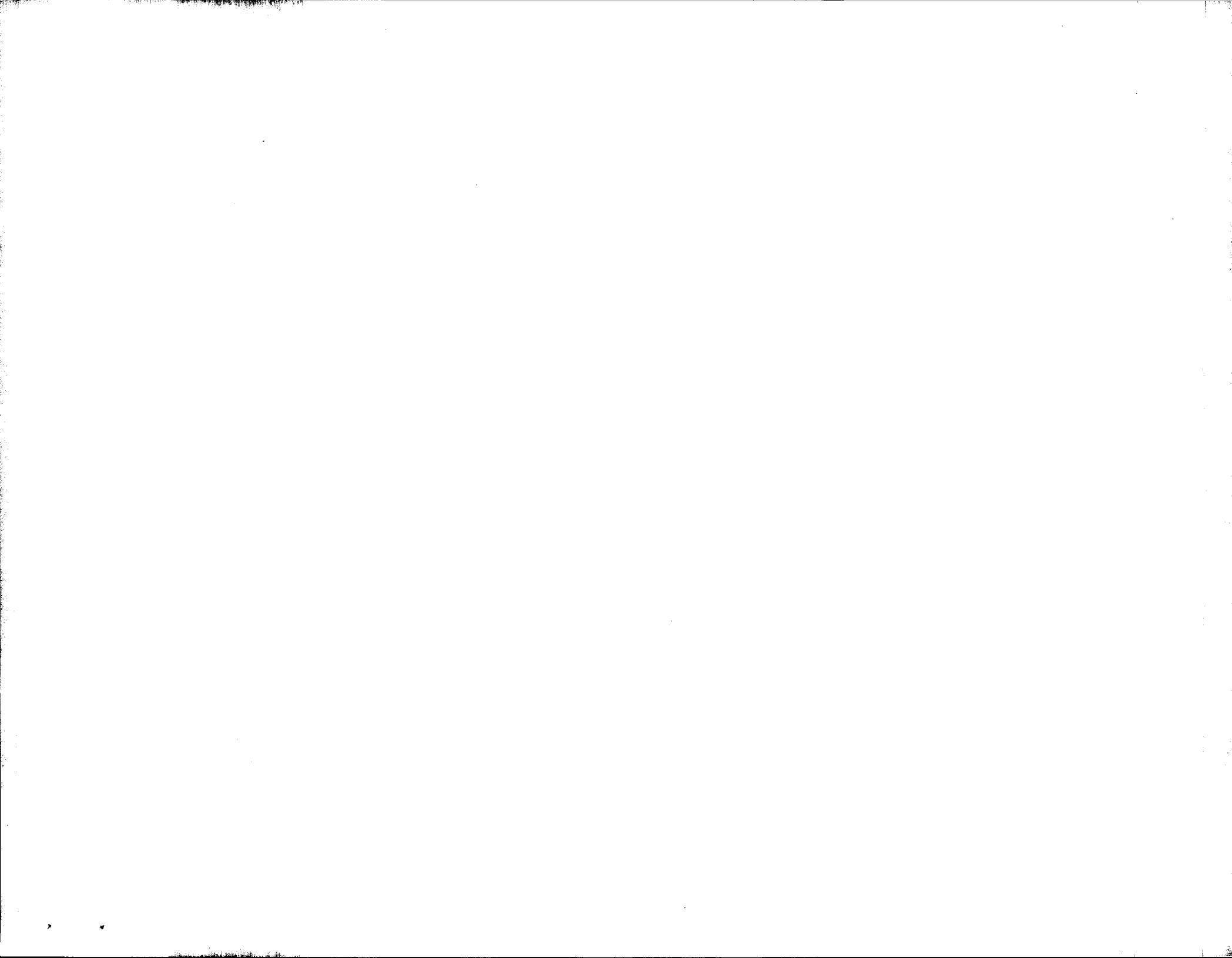
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07-02-12

**D3536-23 GASKET****NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

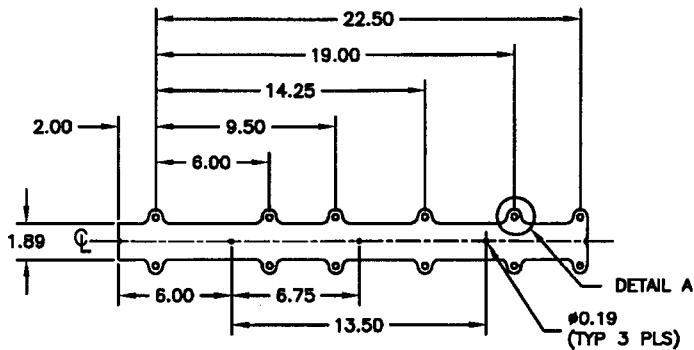
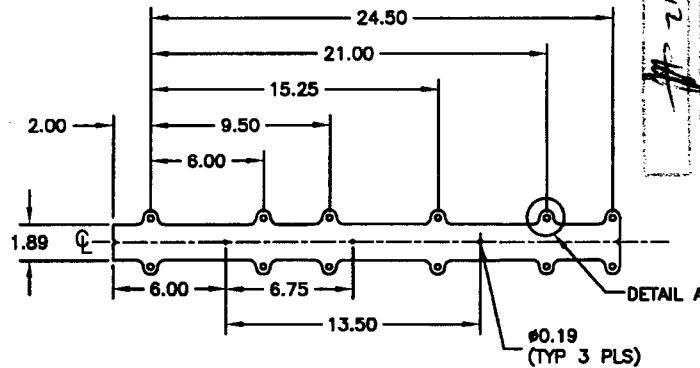
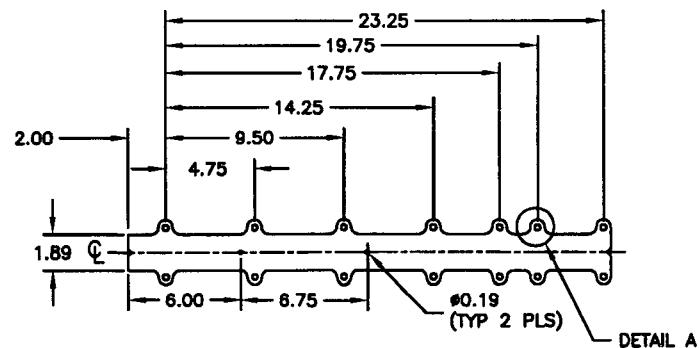
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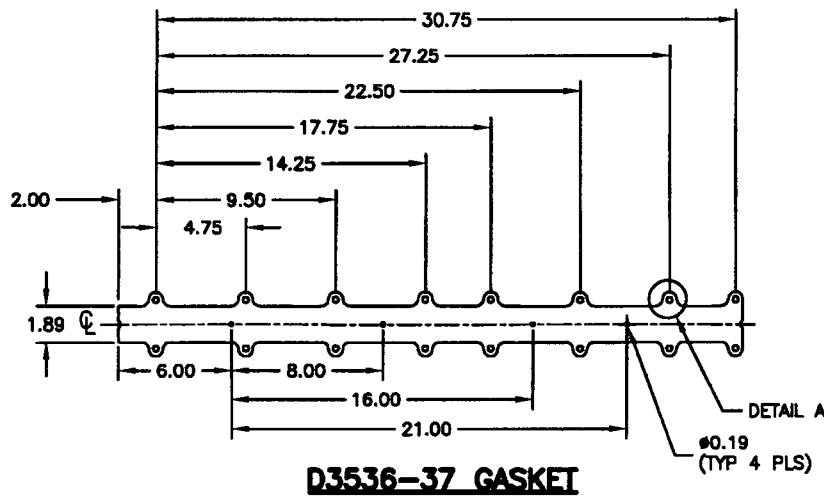
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CHECKED M	APPROVED M	DRAWING NO. D3536
DATE 06.10.25	TITLE GASKET	SHEET 3 OF 6
		SCALE 1:10



DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED M	APPROVED M	DRAWING NO. D3536
DATE 06.10.25		TITLE GASKET
		REV. A SHEET 4 OF 6 SCALE 1:10

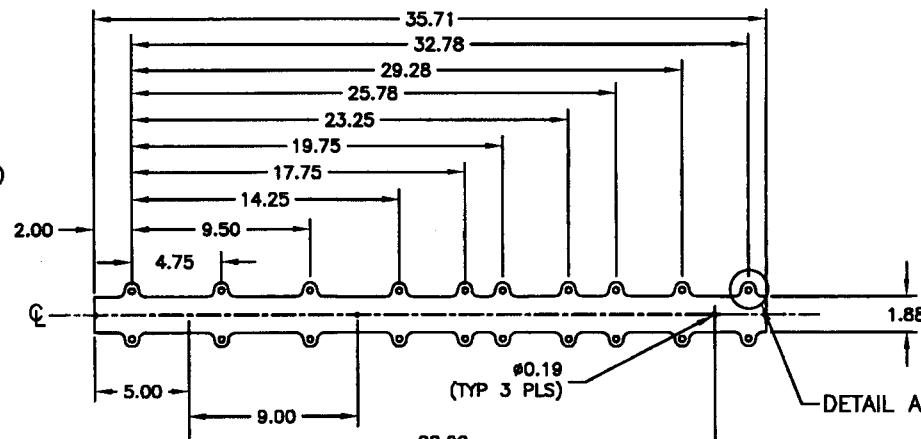
**D3536-31 GASKET****D3536-33 GASKET****D3536-35 GASKET**



D3536-37 GASKET

NOTES

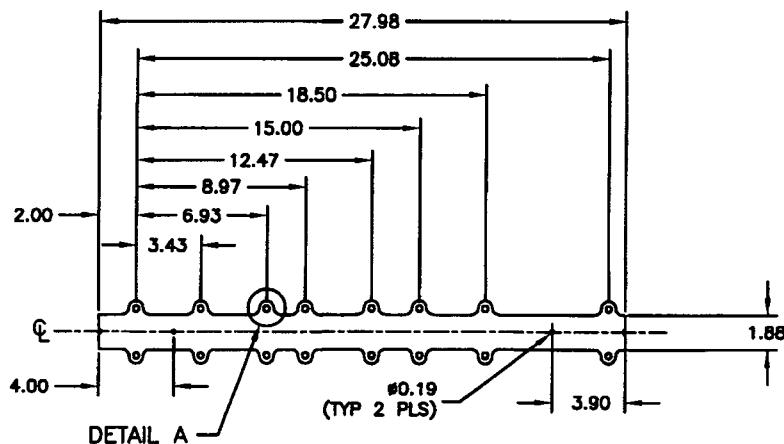
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- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-39 GASKET

DESIGN C.B	DRAWN BY C.B	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED PH	APPROVED HL	DRAWING NO. D3536
DATE 06.10.25		SHEET 5 OF 6 TITLE GASKET SCALE 1:10

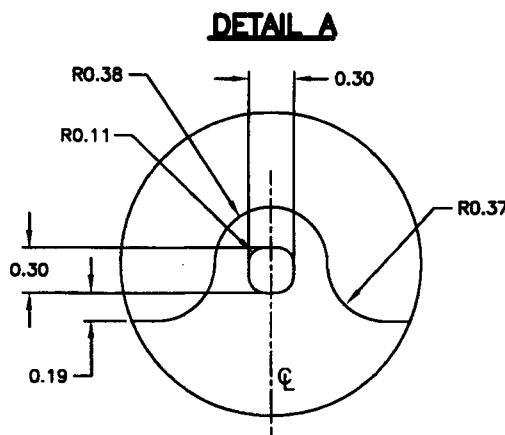
DART



D3536-41 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{Q}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER



DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED PH	APPROVED PH	DRAWING NO. D3536
DATE 06.10.25		SHEET 6 OF 6
		SCALE 1:10

07.02.02 PH

DART